



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3700-C-07

Job Sheet 170613



Part No: RBE350A94-3700-C-07

Job Qty: 18 ea

Part Name: Top



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 18.01.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea	2/13/18	2/13/18	0.00	0.00	Start Up Machining-4		OK 18/02/20
100	Bandsaw	18 pcs	2/13/18	2/13/18	0.00	1.80	Bandsaw1		OK 18/02/20
120	Mori Seiki	18 pcs	2/13/18	2/13/18	0.00	9.00	MORI NV5000-1		OK 18/02/20
130	QC	18 pcs	2/13/18	2/13/18	0.00	0.00	QC2 Machining-2		OK 18/02/20
140	QC	18 pcs	2/13/18	2/13/18	0.00	0.00	QC8 Machining-3		OK 18-02-21
150	Outsource	18 pcs	2/13/18	2/13/18	0.00	0.00	Outsource4		AT 18/02/28
160	Packaging	18 pcs	2/13/18	2/13/18	0.00	0.00	Packaging2		AT 18/02/28
170	QC	18 pcs	2/13/18	2/13/18	0.00	0.00	QC6		38 9-88
180	Packaging	18 pcs	2/13/18	2/13/18	0.00	0.00	Packaging3-2	6A MAR 0 1 2018	21 9-88
190	QC21-SA	18 Ea	2/13/18	2/13/18	0.00	0.00	QC21		DAS 21 MAR 0 2 2018

Part Op 100 - Cut blanks to 1.350" T blank. MAKE 4 parts

Descriptions: 120 - 1-Machine as per folio FB 775

FOLIO REV: _____ DWG REV: _____ 2-Deburr

150 - -Issue P/O to ATG : PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.000	6061-T6 Bar .750 X 1.00	1.4400 ft (.08 ea)	90-Start up Operation	
		1.67 1.092		

Part Specifications

Specifications could not be found.

S008422 * S043917

Plex 1/17/18 11:37 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S043918



Part: RBE350A94-3700-C-07

Job No: 170613

Serial No/Batch: S043918

Revision: RBE350A94-3700-C

Inspector:

Date: 02/20/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

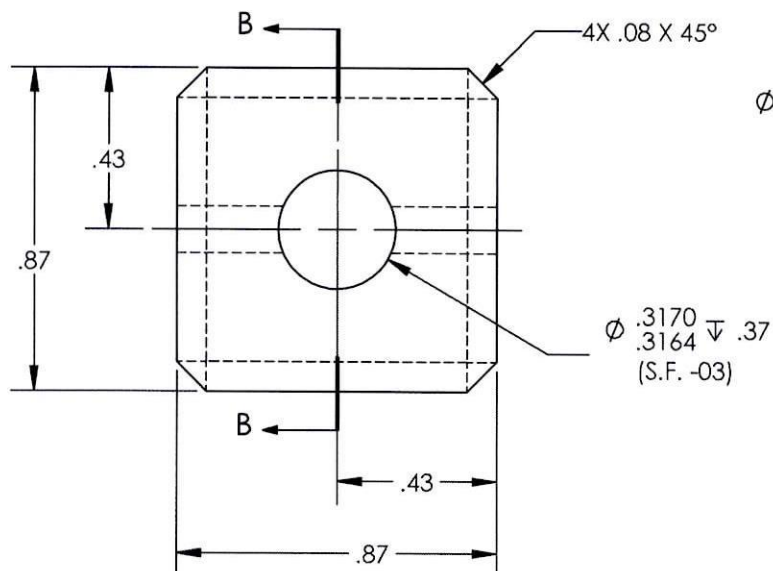
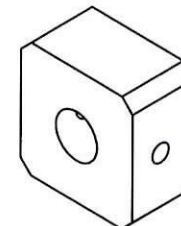
QA Closed: _____ Date: _____

Work Order update only ☐

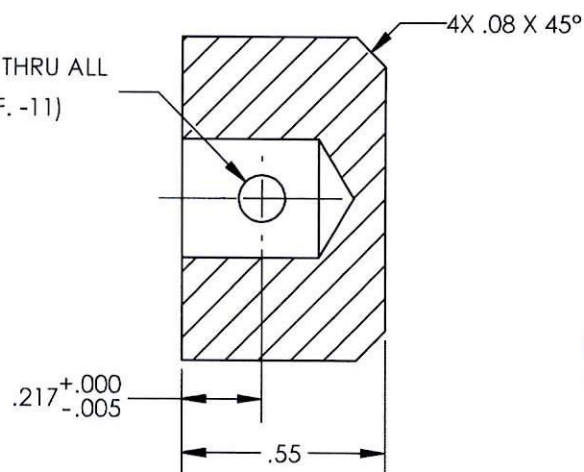
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	15-0213	-07 CH'D HOLE WAS Ø3 mm IS .129 - .125, CH'D DIM WAS Ø.315 S.F. -03 IS Ø.3170 - .3164 ∇ .36.	8/14/2015	RJC	JAG
6	16-0286	-07 CH'D DIM WAS Ø.3170/.3164 ∇ .36 IS Ø.3170/.3164 ∇ .37 (S.F. -03), WAS Ø.129/.125 THRU IS Ø.129/.125 THRU ALL (P.F. -11), WAS .217 IS .217 +.000/-.005, WAS .551 IS .55.	2/28/2017	RJC	SM



Ø.129
THRU ALL
(P.F. -11)



SECTION B-B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170613 MJS
18-01-19

(-07)

TOP

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C-07	REV 6
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH RED ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 2:1	DATE 8/21/2012 SHEET 6 OF 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039091

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Anodize as per Dwg 647.7800 Rev. A 2- PRIME AS PER DWG 648.7800 Rev. A							
8	170489	650.9201	Eyelet Bracket Assembly Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	3/1/18	16 pcs	0 pcs	16 pcs	\$8.05/pcs	\$128.80
9	170613	RBE350A94-3700-C-07	Top -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A94-3700-C-07 Rev 6 -Certificate of Conformity is required	Firmed	3/1/18	18 pcs	0 pcs	18 pcs	\$5.15/pcs	\$92.70
							✓ 18 x	AT 18/02/18		
10	170593	RBE703A95-0505-00-1	Quill -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0505-00-1 Rev. 9 -Certificate of Conformity is required	Firmed	3/1/18	19 pcs	0 pcs	19 pcs	\$5.15/pcs	\$97.85
							✓ 19 x	AT 18/02/18		
11	171154	RBE350A94-2708-01-01	Slide -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As per Dwg RBE350A94-2708-01-01 Rev. G -Certificate of Conformity is required	Firmed	3/1/18	6 pcs	0 pcs	6 pcs	\$6.25/pcs	\$37.50
							✓ 6 x	AT 18/02/18		
12	171014	RBW6405G02131-3G-3	Bell -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal - Certificate of Conformity is required	Firmed	3/1/18	2 pcs	0 pcs	2 pcs	\$6.25/pcs	\$12.50
13	170432	RBT18538-3	Right Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is	Firmed	3/1/18	6 pcs	0 pcs	6 pcs	\$6.25/pcs	\$37.50
							✓ 6 x	AT 18/02/18		



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914683

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
19 ea	Part: RBE703A95-0505-00-1 Quill Anodize per MIL-A-8625F, Type II, Class 2, Red .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22586	Rev: 9 PO: PO039091 Line: 10	
6 ea	Part: RBE350A94-2708-01-01 Slide Anodize per MIL-A-8625F, Type II, Class 2, Black .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22587	Rev: G PO: PO039091 Line: 11	
4 ea	Part: RB1741145 Indicator Test Element Anodize per MIL-A-8625F, Type II, Class 2, Red .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22591	Rev: 1 PO: PO039091 Line: 15	
18 ea	Part: RBE350A94-3700-C-07 Top Anodize per MIL-A-8625F, Type II, Class 2, Red .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22585	Rev: 6 PO: PO039091 Line: 9	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>28/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914683

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	